

Work Order ID 62935



Page 1

Wednesday, October 13, 2010 2:54:33 PM

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 10/13/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *MP*

Date: 10-10-13

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3836	Rev A

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open
to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 111585

6- grind weld flush where indicated on dwg

3AD10-10-13

(2) *JL 10-10-13*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

H 10.10.19

2 of

PD 10.10.19

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2

J 10.10.19

150



Packaging

Packaging

Identify as per dwg & Stock Location: WIA

0.00

Memo

0.00

SAD
10-10-09

W/O:		WORK ORDER CHANGES							
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Wednesday, October 13, 2010 2:54:33 PM

Item ID: D3836-042

Accept



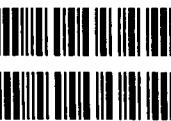
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Stop



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Required Date: 10/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

10/10/2010
MF

10-10-19

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

Wednesday, October 13, 2010 2:54:37 PM

Work Order ID: 62935



Parent Item: D3836-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 10/13/2010

Required Date: 10/21/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 		Manufactured	No			100	Each	33.0000	1	2		GK 10-10-19	

Spacer Bushing

Location	Loc Qty	Loc Code
WA	33	
58974	1	
60320	1	
60952	11	
62108	20	

M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

100 f 678.6362 1.7808



SA D

10-10-15

Location	Loc Qty	Loc Code
MAT	662.0818	
112398	0	
114482	0.0002	
115494	82.0816	3.74991
115593	580	
WA	16.554385	
114520	0.527385	
115274	16.027	

W/O:		WORK ORDER CHANGES					
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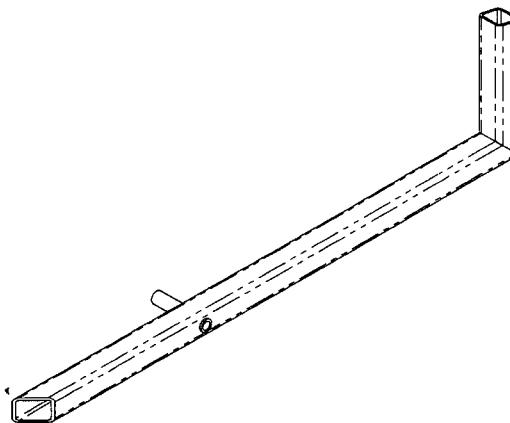
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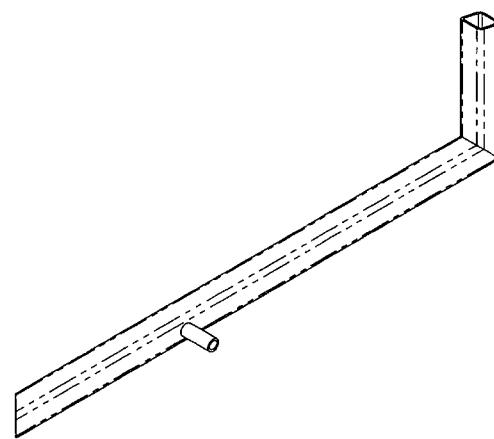
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

SHOP C-1
RETURNED
ENGINEERED
UNCONTROLLED
SUBJECT TO
WIND TUNING
WORK C-1
NO. C2935
B8101013

RELEASED
06/11/2014 MWD

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART
4) UNITS: INCHES UNLESS O
5) BREAK SHARP EDGES: O
6) IDENTIFICATION: N/A
7) WEIGHT: 0.99 lbs EACH
8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKSLEY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8

7

6

5

4

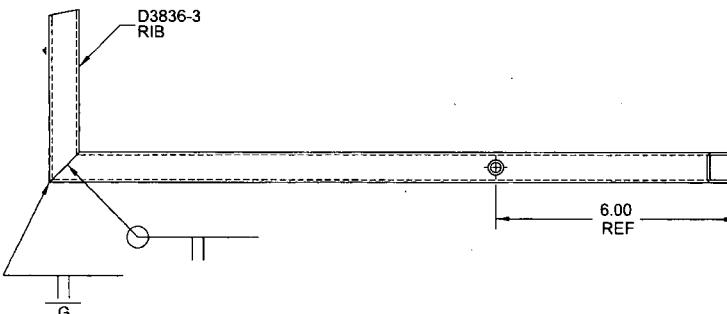
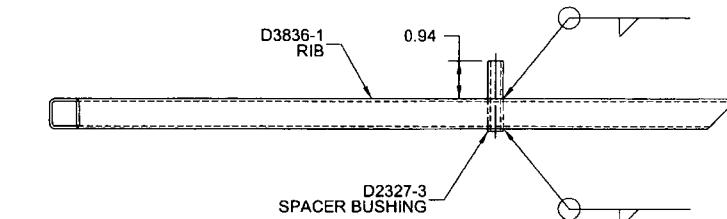
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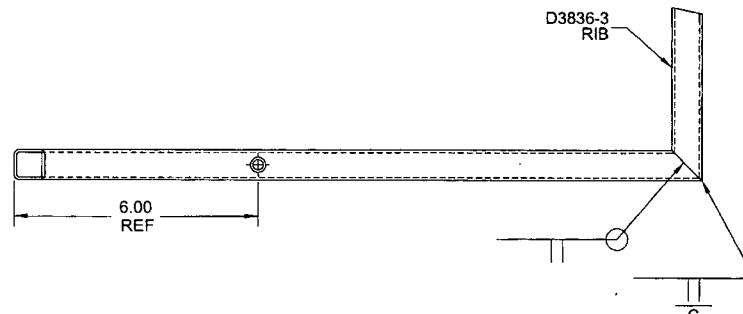
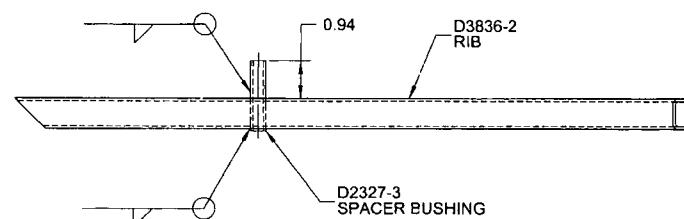
1

D

D



D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

W0 62935

RELEASED
08/11/18 AM

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	MS	DRAWING NO.
MFG. APPR.		D3836
APPROVED		REV. A
DE APPR.		SHEET 2 OF 3
DATE	08.09.24	TITLE
		RIB ASSY (BASKET LID)
		SCALE
		NTS
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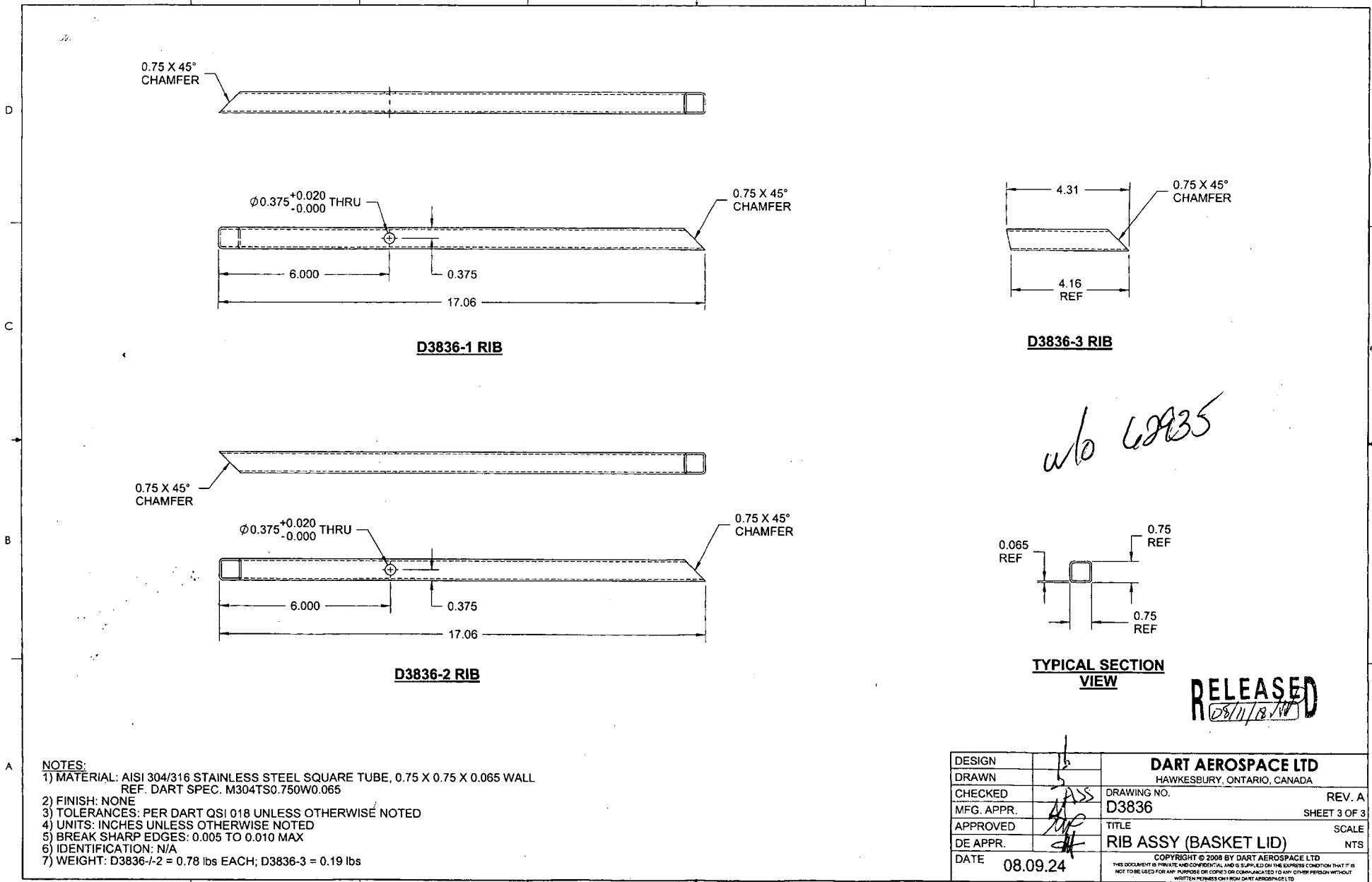
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8 7 6 5 4 3 2 1



DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3836	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
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